

Date: Friday, 7/4/2008 8:47:05 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 40255	
Estimate Number : 11162	
P.O. Number :	Part Number : D32641
This Issue : 7/4/2008 S.O. No. :	Drawing Number : D3264 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 37370	Material :
Written By :	Due Date : 7/22/2008 Qty: 5 Um: Each
Checked & Approved By : <u>HA 08 07 04</u>	
Comment : Est A 04.09.02 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1250X04500	6061-T6 Bar 1.25" X 4.5"
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Comment: Qty.: 0.5097 f(s)/Unit. Total : 3.0580 f(s)
 Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick
 (M6061T6B1.250x04.500)
 Identify for D3264-1
 Batch: M105531

H.A 08/07/05

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 4.500" x 1.250" x 5.700" long Bar

H.A 08/07/05

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA447 and Dwg D3264
 Identify as D3264-1
 Deburr

H.A/mz 08/07/07

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A/mz 08/07/07

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

H.A 08/07/08 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3264-1 PAR #: N/A Fault Category: Prod / Mach. ^{parts} ~~red~~ NCR: Yes No DQA: D Date: 08/07/11
 QA: N/C Closed: D Date: 08/07/11

NCR: <u>40255</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.07.07	3	Tool mark on inner surface RC Tool not pulled out of holder operator error holder not tight enough.	CP 08.07.07 per Q51042	SCRAP no mat. to do a Replacement. Qty <u>(4)</u>	M.A 08/07/07	S 08/07/10	CP 08.07.07 per Q51042	S 08/07/10

NOTE: Date & initial all entries

Date: Friday, 7/4/2008 8:47:05 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 40255

Part Number: D32641

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten: A/BK 08-07-08

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

Handwritten: M107925

START TIME:

Handwritten: 1:15pm

OVEN TEMPERATURE:

Handwritten: 320°F

FINISH TIME:

Handwritten: 1:45pm

Handwritten: 08-07-08

Handwritten: (X5)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: 08/07/08

Handwritten: (5)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location:

Handwritten: 5164

Handwritten: 8/9/9

Handwritten: (5)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 08/07/10

Job Completion



Handwritten: MF 08-07-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 40255
Description: Bracket		Part Number: D3264-1
Inspection Dwg: D3264	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	0.690	✓			
0.063	+/-0.010	0.061	✓			
0.125	+/-0.010	0.125	✓			
0.875	+0.010/-0.020	0.877	✓			
0.062	+/-0.010	0.064	✓			
R0.03	+/-0.030	R0.03	✓			
R0.13	+/-0.030	R0.130	✓			
1.00	+/-0.030	1.004	✓			
0.125	+/-0.010	0.125	✓			
0.600	+/-0.010	0.599	✓			
4.000	+/-0.005	4.000	✓			
0.750	+/-0.010	0.750	✓			
Ø0.194	+0.005/-0.000	Ø0.196	✓			
5.50	+/-0.030	5.501	✓			
0.125	+/-0.010	0.125	✓			
0.063	+/-0.010	0.063	✓			
R0.25	+/-0.030	R0.250	✓			
4.27	+/-0.030	4.269	✓			
R0.30	+/-0.030	R0.30	✓			

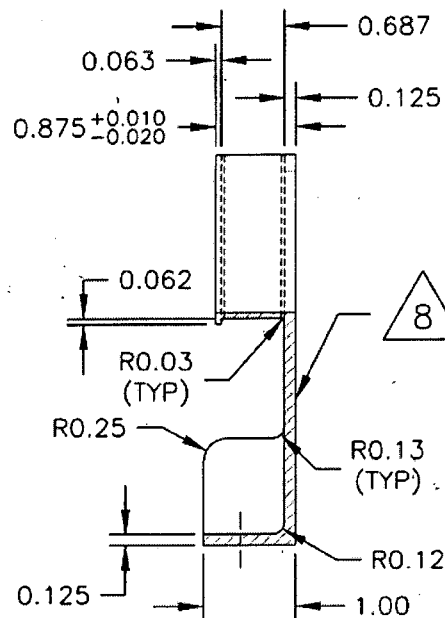
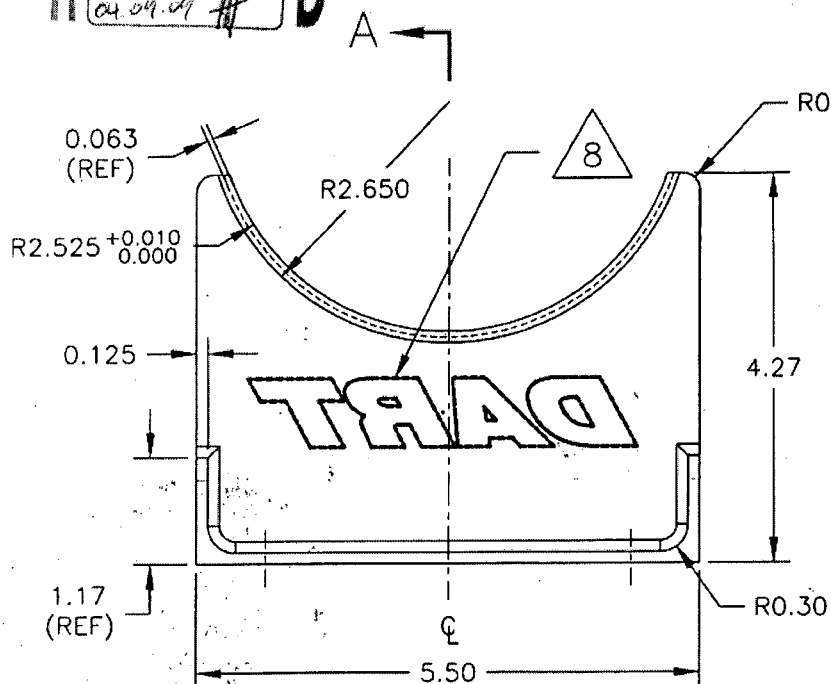
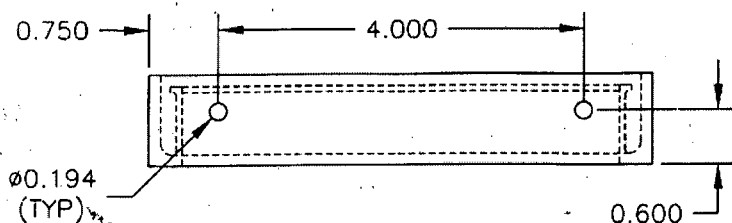
Measured by: M.A. Fink	Audited by: DAP	Prototype Approval:	N/A
Date: 08/07/07	Date: 08/07/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM	
C	07.10.10	Tolerance for 0.875 revised	KJ/EC/DD	

DART

DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3264	REV. A SHEET 1 OF 1
DATE 04.04.20		TITLE BRACKET	SCALE 1:2
A	04.04.20	NEW ISSUE	

RELEASED
04.04.09 #

**SECTION A-A****D3264-1 BRACKET****D3264-1:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061-T651)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40255

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5/7

2/2